

Work Order ID 144439

April 18, 2016 11:18:19 AM

144439

Page 1

Item ID: D412-711-021

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Vertical Reference Door Modification LH

Stop *NS2*

Start Date: 4/20/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: SEA Date: 20160418 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-711	K

~~11/18/15~~ MJS 16-04-26

100	Document Control	0.00	DAS	8					
100	DOCUMENT CONTROL			9-89					
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefiles and create labels per PPP D412-711-021 CHG002								

DAS
27
9-89

16/4/27

120	Pick Kit	0.00							
120	Purchasing								

Packaging	Memo	0.00							
Packaging									

DAS
8
9-89

DAS
28
9-89

APR 27 2016

130	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

130									
QC	Memo	0.03							
Quality Control									

DAS
27
9-89

16/4/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144439***144439***

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Item ID: D412-711-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-711-021								
	Location: _____								
	PPP rev: _____								
	<i>Sold</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

DAS
27
9-89

18/4/25

MCS

APR 28 2016

MCS APR 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
☐ OTHER : _____											

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1 44439

D412-711-021

Required Date: 5/6/2016

Required Qty: 1.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4324-011		Manufactured	No				Each	4.0000		1		6 9-89	DAS 28 9-89
D4324-011 Armrest Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST459				4					
				143367				4					
D412-761-043		Manufactured	No			120	Each	0.0000	1	1		6 9-89	DAS 28 9-89
D412-761-043 Modified Latch Mechanism, LH													
D412-711-101		Manufactured	No			120	Each	0.0000	1	1		6 9-89	DAS 28 9-89
D412-711-101 Replacement Vertical Reference Window													
D3802-1-120		Manufactured	No			120	Each	1.0000	1	1		6 9-89	DAS 28 9-89
D3802-1-120 Window Seal - 120"													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST639				1					
				144284				1					
D4165-1		Manufactured	No			120	Each	0.0000	1	1		6 9-89	DAS 28 9-89
D4165-1 Doubler													

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Work Order ID: 144439

144439

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

D4207-1	Manufactured	No	120	Each	8.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4207-1

Window Retainer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

8

141942

8

D4207-3	Manufactured	No	120	Each	4.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4207-3

Instrument Window

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

4

142232

4

D4269-1	Manufactured	No	120	Each	3.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4269-1

Angle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST089

3

144018

3

D4269-3	Manufactured	No	120	Each	8.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4269-3

Angle

DAS
27
9-89

Location

Loc Qty

Loc Code

ST089

8

141939

8

D4269-5	Manufactured	No	120	Each	0.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4269-5

Angle

DAS
27
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

144019

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Work Order ID: 144439

144439

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

D4269-7

Manufactured No

120 Each

2.0000

1 1

D4269-7

Angle

DAS
6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

2

132994

2

D4327-1

Manufactured No

120 Each

8.0000

1

D4327-1

Angle

DAS
6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

8

141940

8

D4327-3

Manufactured No

120 Each

8.0000

1

D4327-3

Angle

DAS
6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

8

141943

8

D4385-1

Manufactured No

120 Each

11.0000

2

D4385-1

Placard

DAS
6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST095

11

136305

1

144020

10

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DAS
6 28
9-89 9-89

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Work Order ID: 144439

144439

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-3A Purchased No 120 Each 180.0000 22 22
AN3-3A
 Bolt

**

DAS 6 28 9-89

Location	Loc Qty	Loc Code
ST350	180	
m134294	33	
m134376	47	
m134537	100	

15
7

AN3-4A Purchased No 120 Each 322.0000 20 20
AN3-4A
 Bolt

**

DAS 6 28 9-89

Location	Loc Qty	Loc Code
over003	300	
m134502	300	
ST350	22	
m133990	22	

4
16

AN3-6A Purchased No 120 Each 178.0000 26 26
AN3-6A
 Bolt

**

DAS 6 28 9-89

Location	Loc Qty	Loc Code
over003	75	
M134630	75	
ST349	103	
M133932	1	
M134055	102	

26

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Work Order ID: 144439

144439

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-12A Purchased No

120 Each 117.0000 1 1

AN3-12A

Bolt

**

DAS 28
6 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST349 117
m133064 16
m133234 1
m134257 100

NAS1149F0332P Purchased No

120 Each 1,915.000 92 92

NAS1149F0332P

Washer

**

DAS 28
6 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA 312
m133709 312
ST262 1603
m134134 103
m134257 1500

CR3242-4-2 Purchased No

120 Each 155.0000 34 34

CR3242-4-2

RIVET

**

DAS 28
6 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST318 55
m134376 55
ST320 100
m134500 100

34

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Work Order ID: 144439

144439

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-3

Purchased

No

120

Each

3,080.000

135

135

DAS

DAS 28 9-89

MS20426AD3-3

RIVET

**

DAS 6 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

994

M131624

994

ST312

2086

M131624

2086

135

MS20426AD4-3

Purchased

No

120

Each

2,131.000

140

140

DAS 28 9-89

MS20426AD4-3

Rivet

**

DAS 6 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

1171

113064

171

m125807

1000

ST312

960

m125807

960

140

MS20470AD3-3

Purchased

No

120

Each

6,347.000

25

25

DAS

28

MS20470AD3-3

RIVET, UNIVERSAL HEAD

**

DAS

6 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

877

1065

877

ST310

5470

16941

5470

25

APR 27 2016

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Work Order ID: 144439

144439

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-3

Purchased

No

120

Each

967.0000

90

90

MS20470AD4-3

Rivet - Universal Head

DAS

DAS 28
6 9-89
9-89

Location

Loc Qty

Loc Code

GA

760

2193

760

ST310

207

2193

207

MS21042L3

DAS
27

Purchased

No

120

Each

1,780.0000

24

24

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

782

m133790

3

m134360

779

ST304

898

m134039

12

m134360

886

DAS
27
9-89

DAS 28
6 9-89
9-89

APR 27 2016

24

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Work Order ID: 144439

144439

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased

No

120

Each

179.0000

4

4

MS21059L3

Nut Plate

DAS 28
6 9-89
9-89

Location

Loc Qty

Loc Code

CA

8

M129682

8

GA

30

M133990

30

ST301

115

M134055

15

M134257

50

M134509

50

ST303

26

M133016

26

DAS
27
9-89

MS21069L3

Purchased

No

120

Each

100.0000

34

34

MS21069L3

ANCHOR NUT

DAS 28
6 9-89
9-89

Location

Loc Qty

Loc Code

ST299

100

m134509

100

DAS
27
9-89

MS21069L08

Purchased

No

120

Each

582.0000

8

8

MS21069L08

ANCHOR NUT

DAS 28
6 9-89
9-89

Location

Loc Qty

Loc Code

ST299

582

123522

582

DAS
27
9-89

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Work Order ID: 144439

144439

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 4/20/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS21071L3

Purchased

No

120

Each

194.0000

3

3

DAS 28
6 28
9-89 9-89

MS21071L3

ANCHOR NUT

**

Location

Loc Qty

Loc Code

ST299

94

m129702

94

ST301

100

125654

100

120

Each

158.0000

1

1

**

MS21071L08

Purchased

No

MS21071L08

ANCHOR NUT

Location

Loc Qty

Loc Code

ST299

158

102587

58

103447

100

DAS 27
6 28
9-89 9-89

APR 27 2016

DAS 28
9-89

52.9 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -041	Qty -043	Part Number	Description
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
					X			D412-711-021	VERTICAL REFERENCE DOOR KIT
A ₁	A ₁	A ₁	A ₁	A ₁		X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1	1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1	1		D412-711-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1	1		D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1	1		D4165-1	DOUBLER
					1	1		D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1	1		*D4165-5	AFT RIB (REPLACES EA20469-34)
					1	1		**D4165-7	FWD RIB (REPLACES EA20469-31)
					1	1		D4165-9	ANGLE (REPLACES EA20469-17)
					1	1		D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1	1		D4207-1	WINDOW RETAINER (REPLACES EA20469-14)
					1	1		D4207-3	WINDOW (REPLACES EA20469-13)
					1	1		*D4269-1	ANGLE (REPLACES EA20469-33)
					1	1		**D4269-3	ANGLE (REPLACES EA20469-30)
					1	1		**D4269-5	ANGLE (REPLACES EA20469-29)
					1	1		*D4269-7	ANGLE (REPLACES EA20469-32)
					1	1		D4324-011	ARM REST ASSEMBLY (REPLACES EA20469-16)
					1	1		D4327-1	ANGLE (REPLACES EA20469-11)
					1	1		D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

* PART OF EA20469-10 REAR RIB ASSEMBLY

** PART OF EA20469-12 FWD RIB ASSEMBLY

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52-00-00

Revision: 2

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -041	Qty -043	Part Number	Description
					22	22		AN3-3A	BOLT
					20	20		AN3-4A	BOLT
					26	26		AN3-6A	BOLT
					1	1		AN3-12A	BOLT
					92	92		NAS1149F0332P	WASHER (OR AN960-10L)
					34	34		CR3242-4-2	RIVET
					135	135		MS20426AD3-3	RIVET
					140	140		MS20426AD4-3	RIVET
					25	25		MS20470AD3-3	RIVET
					90	90		MS20470AD4-3	RIVET
					24	24		MS21042L3	NUT
					4	4		MS21059L3	NUT PLATE
					34	34		MS21069L3	NUT PLATE
					8	8		MS21069L08	NUT PLATE
					3	3		MS21071L3	NUT PLATE
					1	1		MS21071L08	NUT PLATE
						1		204-030-853-125	LH COPILOT DOOR (204-030-853-137/-155)
1								D412-711-111	WIRING HARNESS, 212/412
B ₁								^B D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1							D205-711-113	WIRING HARNESS, 205
	B ₁							^B D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1						D204-711-115	WIRING HARNESS, 204
		B ₁						^B EA20469-15-204	INSTRUMENT PANEL, 204
			1					D214-711-117	WIRING HARNESS, 214
			B ₁					^B EA20469-15-214	INSTRUMENT PANEL, 214
					1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
					B ₁			^B D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

(A) IF CUSTOMER PREFERS TO SUPPLY AND MODIFY THEIR OWN DOOR, D412-711-021 SHOULD BE SUPPLIED IN LIEU OF D412-711-041.

(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE.

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